Date: Monday, 18/08/2008 3:44:40 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	**Drawing Name**	: AFT ADJUSTABLE BLADE SUPPORT ASSY
Job Number	: 41366		
Estimate Number	: 13436		
P.O. Number	:	**Part Number**	: PB674300113
This Issue	: 18/08/2008 **S.O. No.** :	**Drawing Number**	: B6743001 P.8
Prsht Rev.	: NC	**Project Number**	: N/A
First Issue	: / / **Type** : LARGE FAB ASSY	**Drawing Revision**	: B1
Previous Run	: 40607	**Material**	:
Written By	:	**Due Date**	: 18/09/2008 **Qty:** 8 **Um:** Each
Checked & Approved By	: JD08.8.P		
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	PB6743001255	Inner Tube
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Inner Tube batch: B41484	08.09.27 2
2.0	PB6743001249	Inner Tube Bushing
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Inner Tube Bushing batch: M18147	08.09.27 2
3.0	PB6743001253	Gusset
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Gusset batch: ~~B40717~~ 41492	08.09.27 2
4.0	PB6743001254	Gusset
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) Gusset batch: ~~B40053~~ 41493	08.09.27 2
5.0	PB674300167	PB67-43001-67
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) PB67-43001-67 batch: B41214	08.09.27 2

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	**STEP**	**Description of NC** Section A	**Corrective Action** Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

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Job Number: 41366 **Part Number:** PB674300113

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
1- make a 0.090" chamfer in the 1.00" hole before welding
2- assemble parts and weld as per dwg
08.09.29 (X2)

7.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION
BE 08-09-29

8.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP
S 08/09/29 (X2)

9.0	MS124780	HELICAL INSERT

Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
HELICAL INSERT 3 M11935
08.09.29 2

10.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1
1- grind weld flush in area of PB67-43001-249 only
08.09.29 2
2- install helicol insert as per dwg
08.09.29 2

11.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP
~~BE 08/09/29~~ S 08/09/29 (X2)

12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1
M S 08/09/30

13.0	POWDER COATING	POWDER COATING

M102316 (2X)

Comment: POWDER COATING

1- MASK TUBE FROM BASE TO GUSSET

2- Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3
M 08/09/30

Dart Aerospace Ltd

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DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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Date: Monday, 18/08/2008 3:44:40 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** AFT ADJUSTABLE BLADE SUPPORT ASSY

Job Number: 41366 **Part Number:** PB674300113

Job Number:

Seq. #:	Machine Or Operation:	Description :
	START TIME: 9:00 OVEN TEMPERATURE: 320 FINISH TIME: 9:30	2X 08/09/30
14.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	08-09-30 X2
15.0	PB674300169	90 Degree Cover Plate
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) 90 Degree Cover Plate batch: 41518 x4.	08.10.22
16.0	PB674300183	PB67-43001-83
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s) PB67-43001-83 batch: 41516	08.10.22
17.0	MS27039110	Screw
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s) Screw batch: M109031	08.10.22
18.0	NAS1149F0316P	WASHER
	Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s) WASHER batch: M109031	08.10.22
19.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: SMALL & MEDIUM FAB RESOURCE 1 1- match drill cover to existing holes in support 2- assemble as per dwg	~~X4~~ X2 08.10.22

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W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

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			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

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Job Number: 41366 **Part Number:** PB674300113

Job Number:

Seq. #:	Machine Or Operation:	Description :
20.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	08/10/23 #2
21.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_____	Carl welding 08/10/23 #2
22.0	QC21	FINAL INSPECTION/W/O RELEASE
	Comment: FINAL INSPECTION/W/O RELEASE	08/10/23 #2

Job Completion

MF 08-10-23

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

QA: N/C Closed: _____ **Date:** _____

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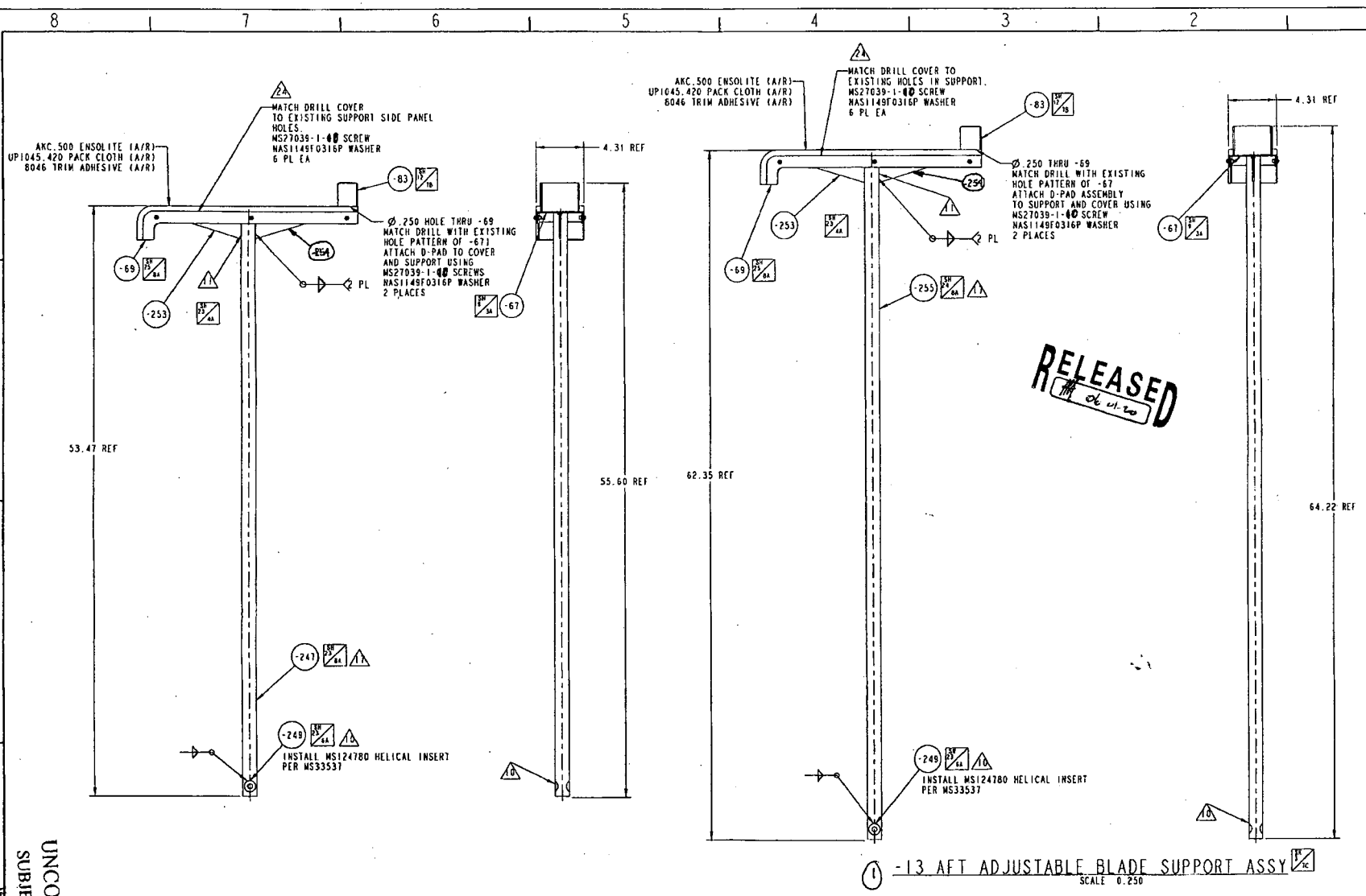
			Initial Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries



RELEASED

① -11 FWD ADJUSTABLE BLADE SUPPORT ASSY

SCALE 0.250

① -13 AFT ADJUSTABLE BLADE SUPPORT ASSY

SCALE 0.250

PREMIER AVIATION, INC.
2602 Aviation Parkway, Grand Prairie, Texas 75052

SIZE	CODE IDENT NO.	DWG NO.	REV.
D	0SUV8	B67-43001	B1

SCALE: WT: SHEET 8 OF 45

ORIGINAL

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WITHOUT NOTICE

WORK ORDER
NO. 41360